

Date: Monday, 2/27/2006 4:18:26 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE SPACER
Job Number	: 25982		
Estimate Number	: 11055		
P.O. Number	: N/A	Part Number	: D2884
This Issue	: 2/27/2006 S.O. No. : N/A	Drawing Number	: D2884 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: <u>See comment below</u>	Due Date	: 3/22/2006 Qty: 40 Um: Each
Checked & Approved By	: <u>KJ 06.02.28</u>		
Comment	: Est A 99.10.12 New Issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S080	5052-H32 .080 Sheet
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Comment: Qty.: 0.0663 sf(s)/Unit Total : 2.6502 sf(s)
 Material: 5052-H32/H34 (QQ-A-250/8) 0.080" Thick
 Batch M19729

ml 06/03/19

40

2.0	SHEAR	SHEAR
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Comment: SHEAR
 1 blank makes 4 parts
 Blank: 7.90" x 4.60" (+0.030" - 0.000")

ml 06/03/19

40

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 1-Machine per folio D2884
 2-Tumble
 3-Deburr any rough edges after tumbling

ml 06/03/19

40

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/03/19

40

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Acid etch and Alodine as per QSI 005 4.1

A.M 06-03-28

(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LS Date: 06/03/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 25982

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ml
~~06/03/28~~ 06/03/28

(40)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *57393*

06/03/29 (40)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/03/30 (40)

Job Completion



u 06/03/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

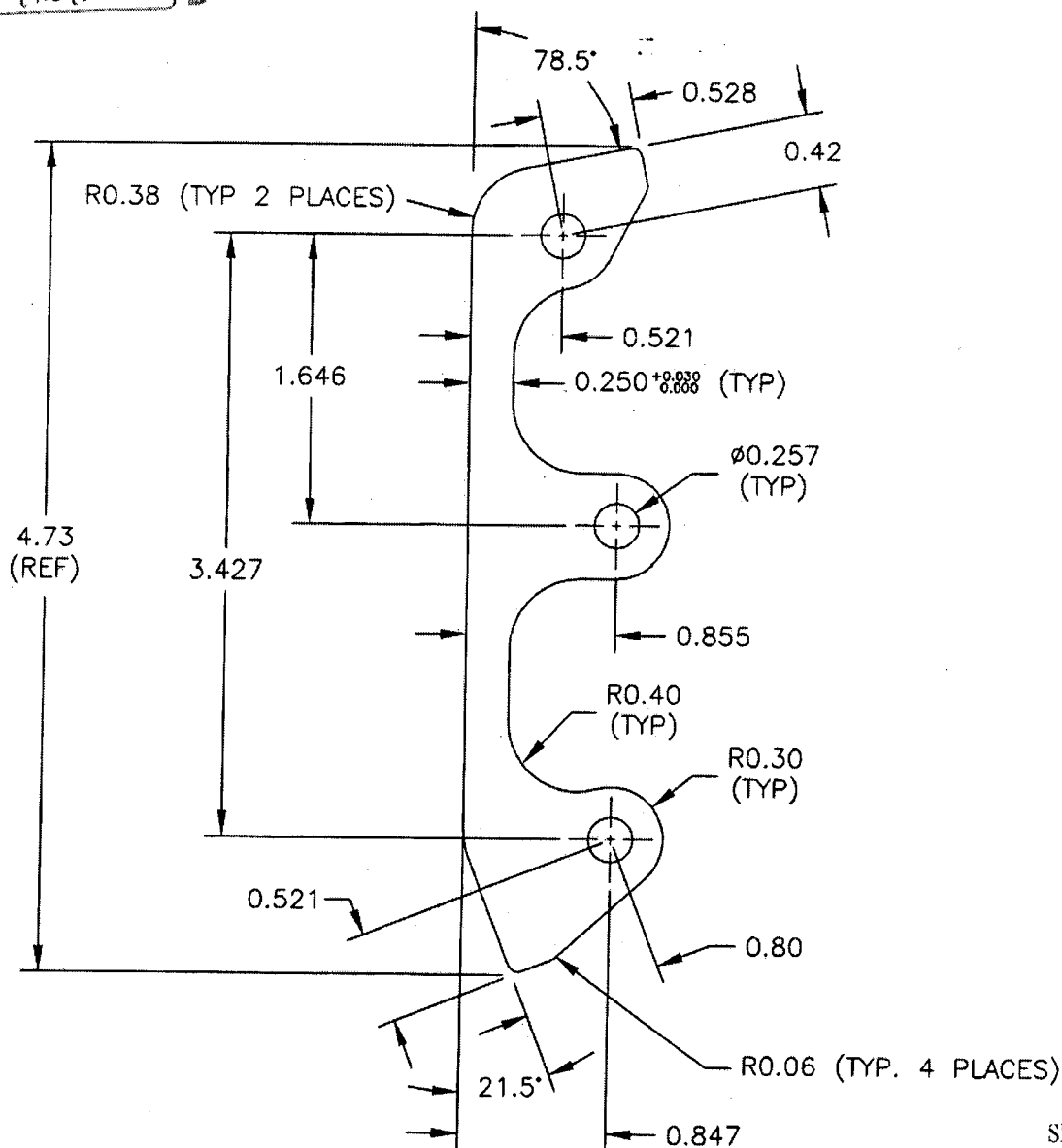
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>DA</i>	APPROVED <i>CP</i>	DRAWING NO. D2884	REV. A SHEET 1 OF 1
DATE 99.04.01		TITLE SADDLE SPACER	SCALE 1:1
A	99.04.01	NEW ISSUE	

RELEASED
99.04.27 DS



MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.080 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL SHARP EDGES 0.010 TO 0.020



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25982

DART AEROSPACE LTD	Work Order:	25982
Description: SADDLE SPACER	Part Number:	D2884
Inspection Dwg: D2884 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

[illegible]

Measured by: 	Audited by: 	Prototype Approval:
Date: 06/03/19	Date: 06-03-19	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	